

Work Order ID 69737

Wednesday, May 18, 2011 10:45:43 AM



Page 1

Item ID: D2438

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 5/18/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

R

Date: 11-05-18

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2438	Rev C								
100	PURCHASING	0.00							
	Waterjet								
	Memo	0.00							
	Cut as per dwg D2438								
	prog rev: <i>E</i>								
	dwg rev: <i>E</i>								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
	Memo	0.00							
	Ensure Material Release Note is attached								
120	QC8- Inspect parts - second check	0.00							
	QC								
	Memo	0.00							
	(6.786" center to center)								

B11-5-22

(108)

B11-5-26

8.11.12

Counted
(X108)
25749

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00				108			
Small Fab	1- Use DT9713 clamp holder to hold clamp in place when forming 2- Bend as per dwg usind DT9709			SB 465/30					
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00		81105/30		108			
Quality Control									
150 	Identify as per dwg & Stock Location: 456	0.00							
Packaging	Memo	0.00							
Packaging									

108

108

108

11/5/30 108

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Start Date: 5/18/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/31 DJ

MF

11-05-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, May 18, 2011 10:45:47 AM

Page 1

Work Order ID: 69737

Parent Item: D2438

Parent Item Name: Clamp



Start Date: 5/18/2011

Required Date: 5/20/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP: E 05.06.28 Bending removed KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

194.8000

0.04

4.210526



304/316 Sheet .063



Bill-5-26

Location

Loc Qty

Loc Code

MAT020

194.8

117275

34.8

117653

160

117653

108

3

W/O:		WORK ORDER CHANGES					
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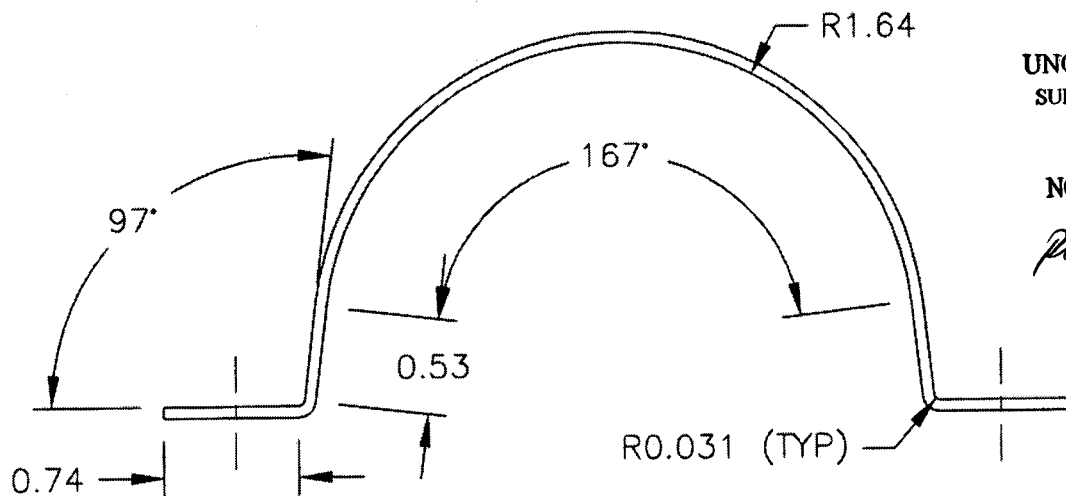
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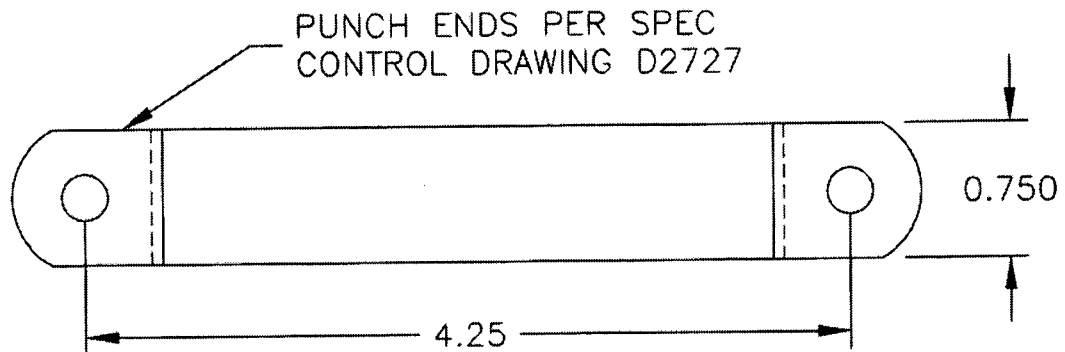


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MD</i>	APPROVED <i>KE</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
98.06.17 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENTS
WITHOUT NOTICE
WORK ORDER
NO. 69237
2/11-05-11



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK
MINIMUM REQUIREMENT IS ANNEALED CONDITION

00.06.06
CP 00.06.07

W/O:		WORK ORDER CHANGES						
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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